

Date: Monday, 2/11/2008 2:12:09 PM  
 User: Kim Johnston

## Process Sheet

Customer	CU-DAR001 Dart Helicopters Services		Drawing Name	ARM
Job Number	37337		Part Number	D28441
Estimate Number	11047		Drawing Number	D2844 REV A
P.O. Number	:		Project Number	N/A
This Issue	2/11/2008	S.O. No. :	Drawing Revision	A
Prsht Rev.	NC		Material	:
First Issue	11	Type : SMALL /MED FAB	Due Date	2/18/2008
Previous Run	37243		Qty:	40
Written By	<i>John Johnston</i>		Um:	Each
Checked & Approved By				
Comment	Est: B 00.11.01 Removed P/O for Powder Coat - in house process EC			

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	M304TR0500W035	304 RD Tube .500 x .035W 22.314 Comment: Qty.: 1.9941 f(s)/Unit Total : 79.7622 f(s) 304 RD Tube .500 x .035W M304TR0500W035 Punch 304/316 Seamless tubing with 2B finish, 1/2" OD x .035 Wall 21.49" long (Hole ctr. to hole ctr.) using Jig DT 8012 Batch M107166  SB 08/03/10 40
2.0	BRAKE NC	NC BRAKE 40
3.0	QC5	INSPECT WORK TO CURRENT STEP FF 08-03-12 40 Comment: BAND SAW Form per Dwg D2844 using brake and bending Jig DT 8238-B Deburr  5 08/03/13 40
4.0	POWDER COATING	POWDER COATING M 107005 40 Comment: POWDER COATING Powder Coat White Gloss (Ref: 4.3.5.2) as per QSI 005 4.3  08-03-17 40
5.0	QC3	INSPECT POWDER COAT/CHEMICAL CONVERSION 40X Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION  M-1 08/03/17 40

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes  No  DQA: AP Date: 06/03/19  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Job Number: 37337		Part Number: D28441
Job Number: 		
Seq. #:	Machine Or Operation:	Description :
6.0	QC6 	DIMENSIONAL CHECK <i>08-03-18</i> 
Comment: DIMENSIONAL CHECK ensure parts are still as per dwg D2844		
7.0	PACKAGING 1 	PACKAGING RESOURCE #1 
Comment: PACKAGING RESOURCE #1 Identify and Stock Location: <i>ST265</i>		<i>AS 08/03/18</i> 
8.0	QC21 	FINAL INSPECTION/W/O RELEASE 
Comment: FINAL INSPECTION/W/O RELEASE		<i>PD 08/03/19</i>
Job Completion 		<i>2008/3/18 (40)</i>

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

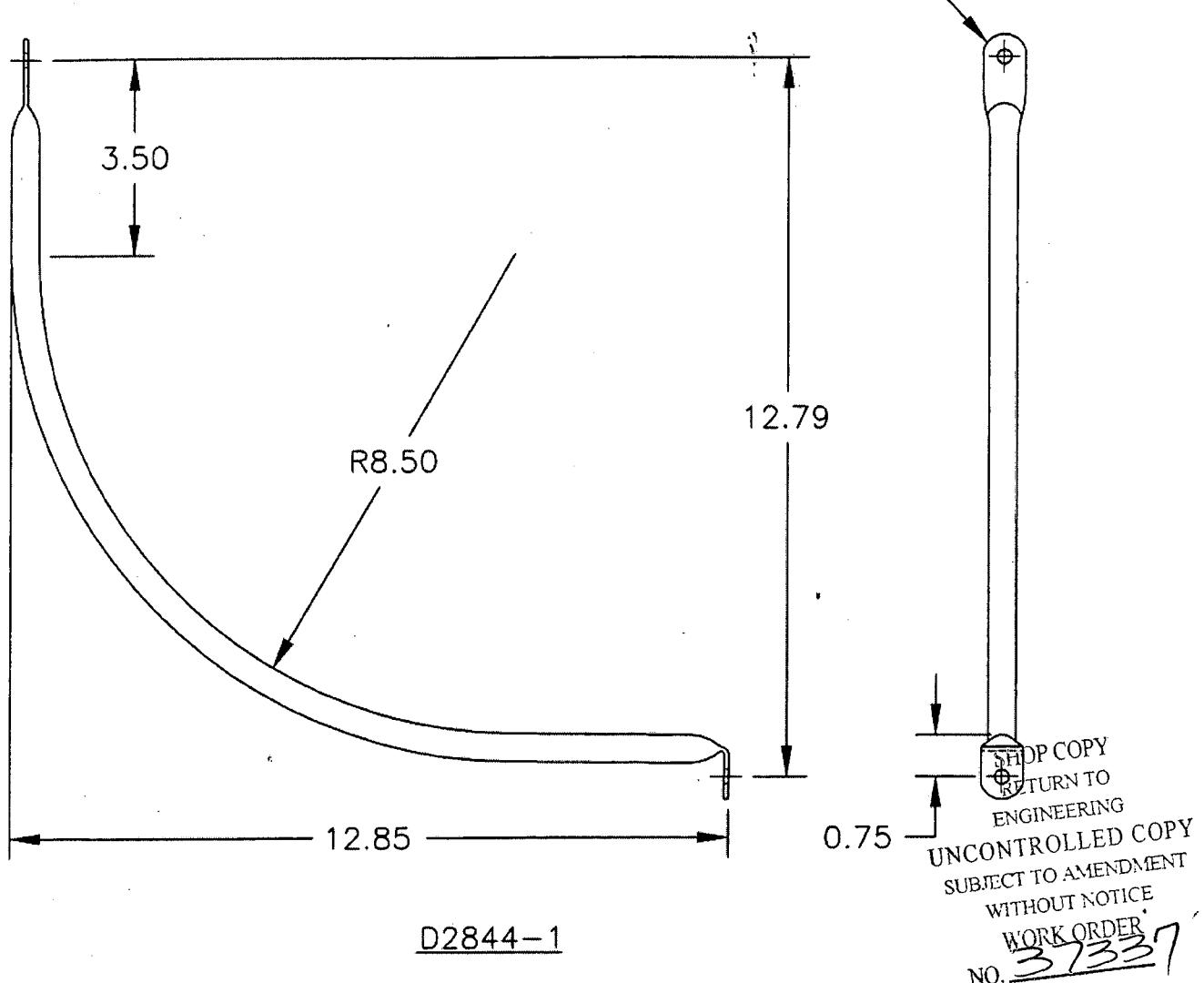
NOTE: Date & initial all entries



DESIGN <i>KE</i>	DRAWN BY <i>KE</i>	DART AEROSPACE USA, INC. FAIRCHILD INTERNATIONAL AIRPORT, WA
CHECKED <i>PAH</i>	APPROVED <i>JS</i>	DRAWING NO. D2844
DATE 98.10.14		TITLE ARM
		SCALE 1:3
A	98.10.14	NEW ISSUE

RELEASED  
98.11.11 KE

PUNCH ENDS PER SPEC CONTROL DRAWING D2727



MATERIAL: AISI 304/316 SS TUBE,  $\phi 0.50 \times 0.035$  WALL  
ENSURE TUBE IS SEAMLESS

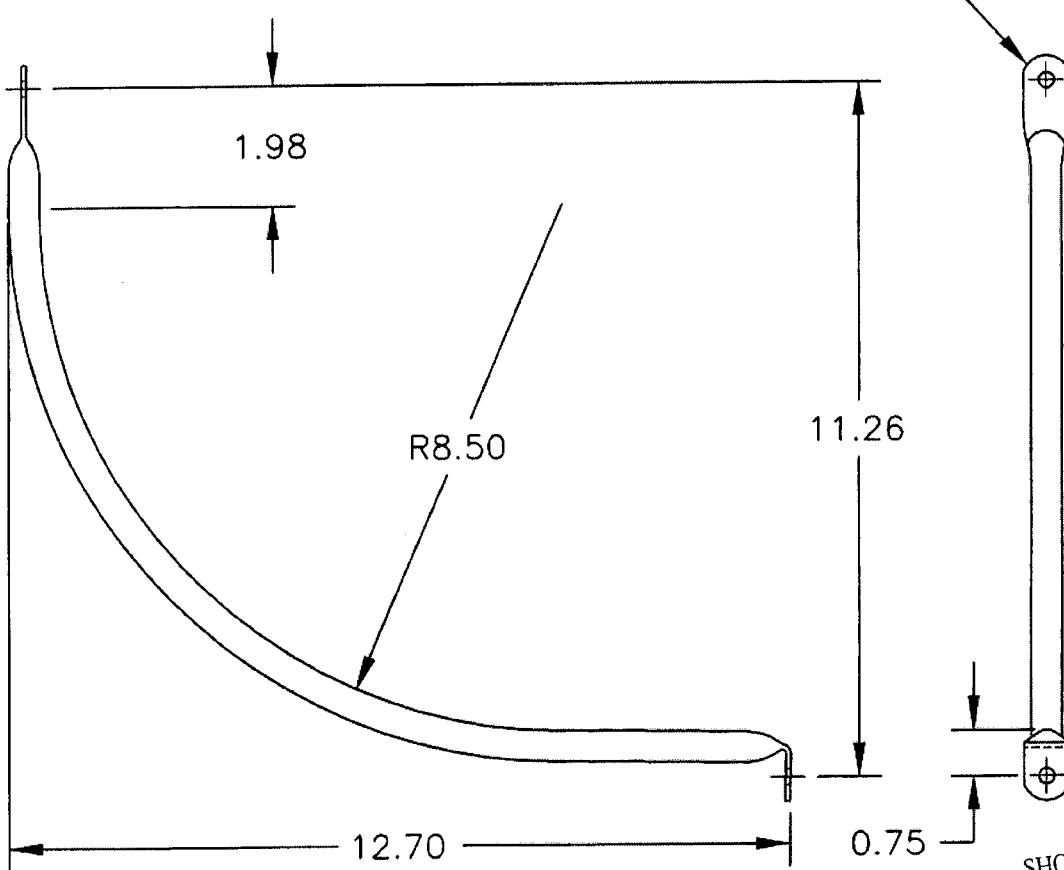
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED  
FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3



DESIGN <i>KE</i>	DRAWN BY <i>KE</i>	DART AEROSPACE USA, INC. FAIRCHILD INTERNATIONAL AIRPORT, WA
CHECKED <i>PA</i>	APPROVED <i>AS</i>	DRAWING NO. D2844
DATE 98.10.14	TITLE ARM	REV. A SHEET 2 OF 2 SCALE 1:3

RELEASED  
19.11.11 KE

PUNCH ENDS PER SPEC CONTROL DRAWING D2727



SHOP COPY  
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SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 37337

MATERIAL: AISI 304/316 SS TUBE,  $\phi 0.50 \times 0.035$  WALL  
ENSURE TUBE IS SEAMLESS

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FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3